



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB 92700-10305-041
Job Sheet 190306



Part No: RB 92700-10305-041

Job Qty: 2 pcs

Part Name: Tail Gear Box & Input Gear Box Seal Installer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/19

Job Tracking No: SIOP

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RB 92700-10305-041 Rev.A IPP Rev. A 18.10.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Small Fab - 1	2 pcs	3/15/19	3/15/19	0.00	0.00	Start Up Small Fab-4		
110	Small Fab - 2 - B4B	2 pcs	3/15/19	3/15/19	0.00	0.40	Small Fab-4		AP 2019/02/27
							External Load - 1 - B4B		
							External Load - 2 - B4B		
							External Load - 3 - B4B		
							Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	2 pcs	3/15/19	3/15/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	3/15/19	3/15/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B	DAS	
				Packaging 3 - 6 - B4B	28	
				Packaging 3 - 7 - B4B	9-89	
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140	QC 21 - FG	2 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21
					QC 21 - FG - 53	9-89

MAR 05 2019

Part Op 90 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-Descriptions: 1200-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1200-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	90-Small Fab - 1	
APP-1200-E	Case	2 Ea (1 ea)	90-Small Fab - 1	
RB 92700-10305-041-2	Top Foam use in case APP-1200-E	2 Ea (1 ea)	90-Small Fab - 1	
RB 92700-10305-041-3	Bottom Foam use in case APP-1200-E	2 Ea (1 ea)	90-Small Fab - 1	
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	90-Small Fab - 1	
RB 92700-10305-041-4-PO	Tail Gear Box & Input Gear Box Seal Installer Assembly	2 pcs (1 ea)	110-Small Fab - 2 - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - 1	97524A032	8	422	0
	APP-1200-E	2	11	0
	RB 92700-10305-041-2	2	0	0
	RB 92700-10305-041-3	2	0	0
	RB41011	2	401	0
110-Small Fab - 2 - B4B	RB 92700-10305-041-4	2	2	0
Part Specifications				
Specifications could not be found.				

Plex 2/26/19 9:42 AM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

B234

RB 92700-10305-041 Job Sheet 190306



Part No: RB 92700-10305-041

Job Qty: 2 ea

Part Name: Tail Gear Box & Input Gear Box Seal Installer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No: SIOP

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RB 92700-10305-041 Rev.A IPP Rev. A 18.10.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		3/15/19	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	2 pcs		3/15/19	0.00	0.40	Small Fab-4		Michael
120	QC	2 pcs		3/15/19	0.00	0.00	QC5		
130	Packaging	2 pcs		3/15/19	0.00	0.00	Packaging3-1		
140	QC21-FG	2 Ea		3/15/19	0.00	0.00	QC21		

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1200-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	90-Start up Operation	5145165
APP-1200-E	Case	2 Ea (1 ea)	90-Start up Operation	5126605
RB 92700-10305-041-2	Top Foam use in case APP-1200-E	2 Ea (1 ea)	90-Start up Operation	5126603
RB 92700-10305-041-3	Bottom Foam use in case APP-1200-E	2 Ea (1 ea)	90-Start up Operation	5126604
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	90-Start up Operation	5021040
RB 92700-10305-041-4	Tail Gear Box & Input Gear Box Seal Installer Assembly	2 pcs (1 ea)	110-Small Fab	5189939

Job Allocations



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Required	Inventory	Allocated
8	526	0
2	19	0
2	2	0
2	2	0
2	423	0
2	0	0

Container No: S155186



Part: RB 92700-10305-041

Job No: 190306

Serial No/Batch: S155186

Revision: A

Inspector:

Exp Date:

Instructions:

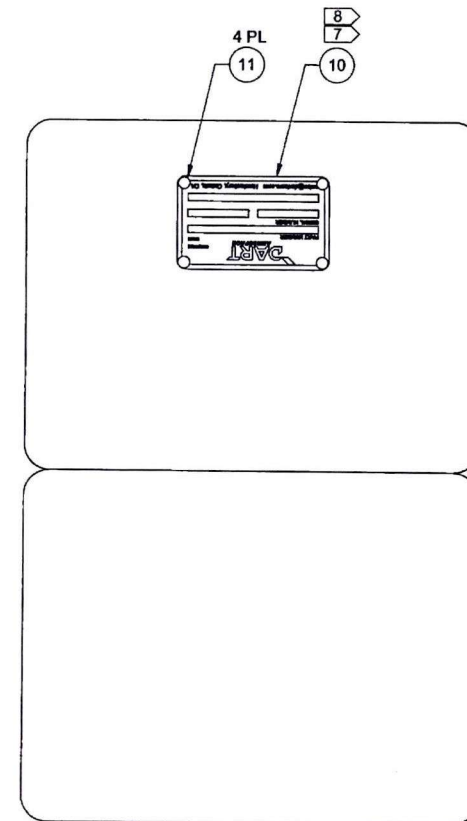
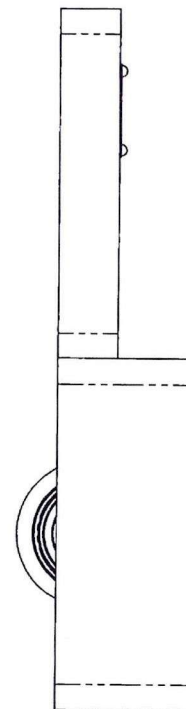
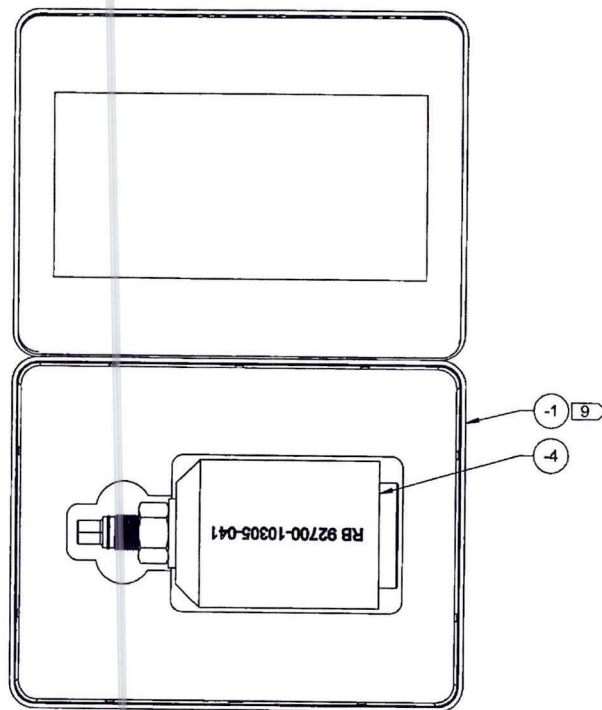
Date: 02/20/19

Plex 2/7/19 8:31 AM Dart.Macdonald.Dara

Part Specifications
Specifications could not be found.

Plex 27/19 8:31 AM Dart.Macdonald.Data

ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10305-041-1	PACKAGING ASSY
-4	1	RB 92700-10305-041-4	TGB & IGB SEAL INSTALLER ASSY
10	1	RB41011	DART PLACARD
11	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED

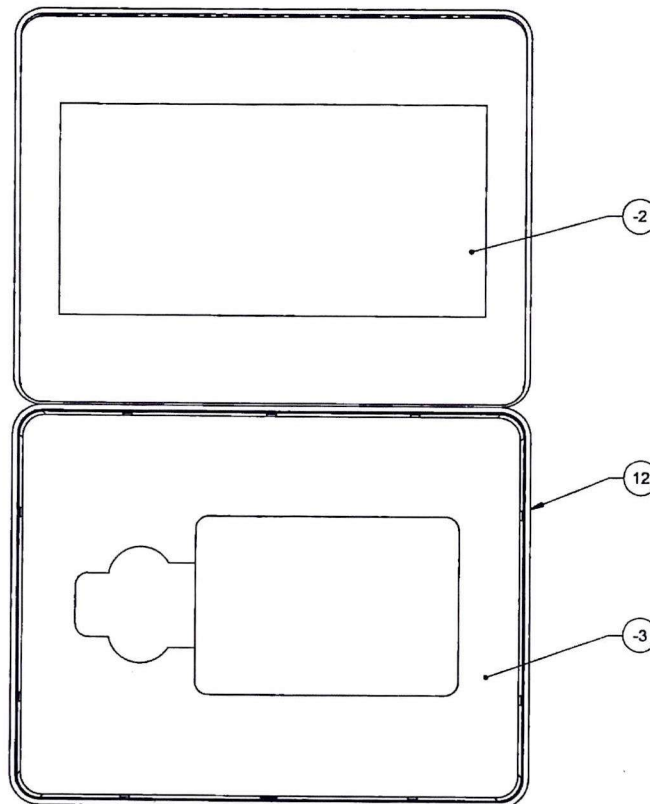
8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS

9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

RB 92700-10305-041 TGB & IGB SEAL INSTALLER

A	NEW ISSUE	18-800	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB 92700-10305-041 TITLE TGB & IGB SEAL INSTALLER DATE 9/10/2018 COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	VM		
CHECKED	VM		
MFG. APPR.	DP		
APPROVED	VM		
REV. A		SHEET 1 OF 10	SCALE
NTS			

ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10305-041-2	TOP FOAM
-3	1	RB 92700-10305-041-3	BOTTOM FOAM
12	1	PELICAN #APP-1200-E	PELICAN CASE 1200



RB 92700-10305-041-1 PACKAGING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

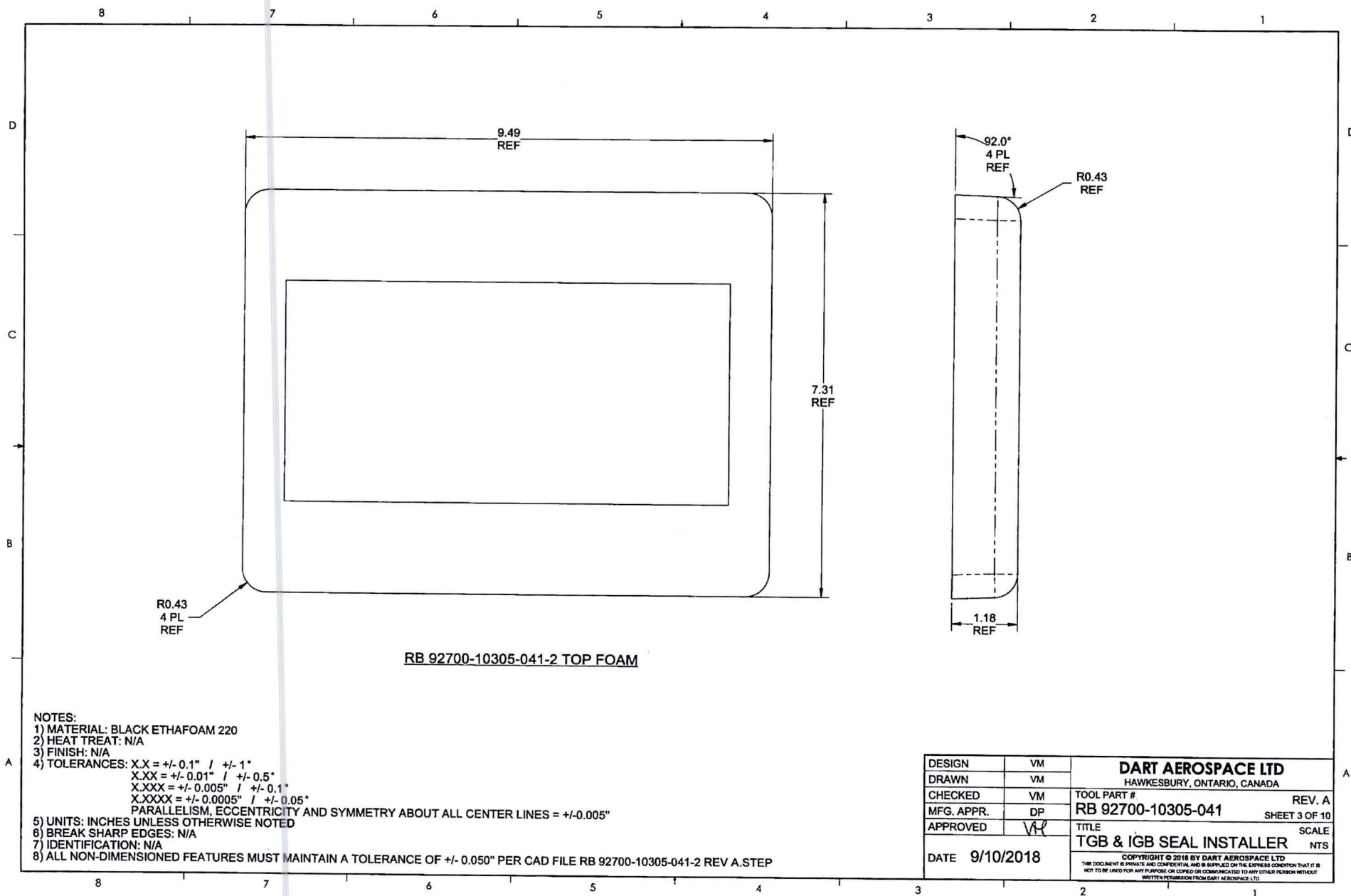
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 2 OF 10
APPROVED	VP	TITLE	SCALE
DATE 9/10/2018		TGB & IGB SEAL INSTALLER	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



RB 92700-10305-041-2 TOP FOAM

NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$

X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$

X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$

X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

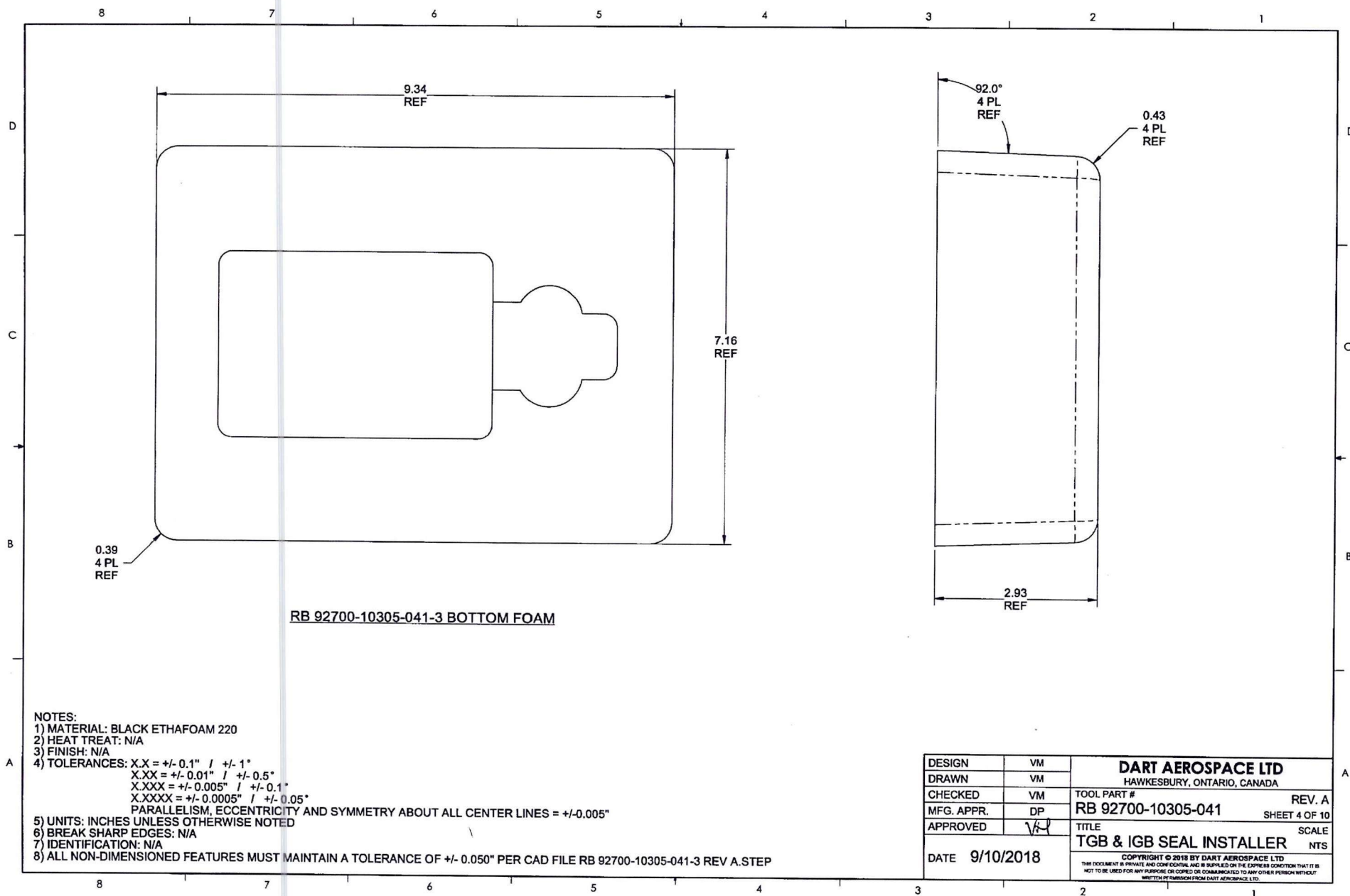
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

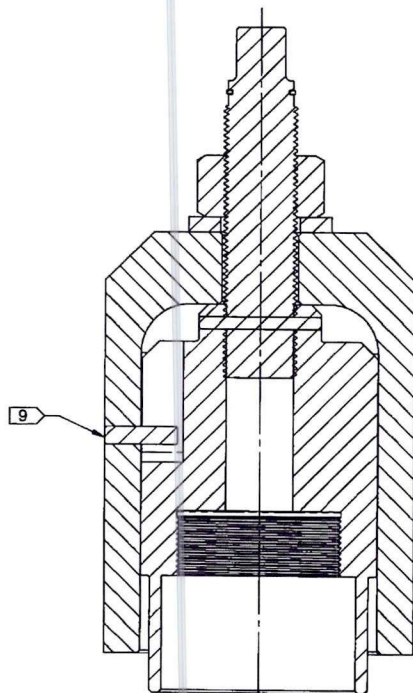
7) IDENTIFICATION: N/A

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF $\pm 0.050"$ PER CAD FILE RB 92700-10305-041-2 REV A.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 3 OF 10
APPROVED	VR	TITLE	SCALE
		TGB & IGB SEAL INSTALLER	NTS
DATE	9/10/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM #	QTY	PART #	PART TITLE
-5	1	RB 92700-10305-041-5	PUSHER ASSY
-8	1	RB 92700-10305-041-8	REACTOR ASSY
13	1	McMaster#98023A036 OR EQUIV	STEEL FLAT WASHER FOR 3/4" SCREW
14	1	McMaster#94895A840 OR EQUIV	STEEL HEX NUT 3/4"-16
15	1	McMaster#98410A126 OR EQUIV	STEEL EXTERNAL RETAINING RING FOR 5/8" OD



RB 92700-10305-041-4 TGB & IGB SEAL INSTALLER ASSY

10

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

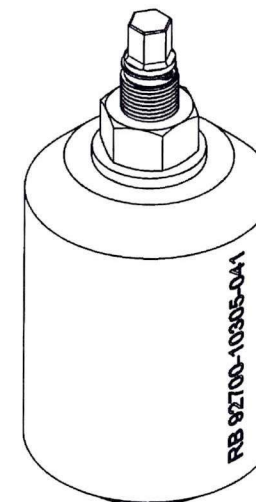
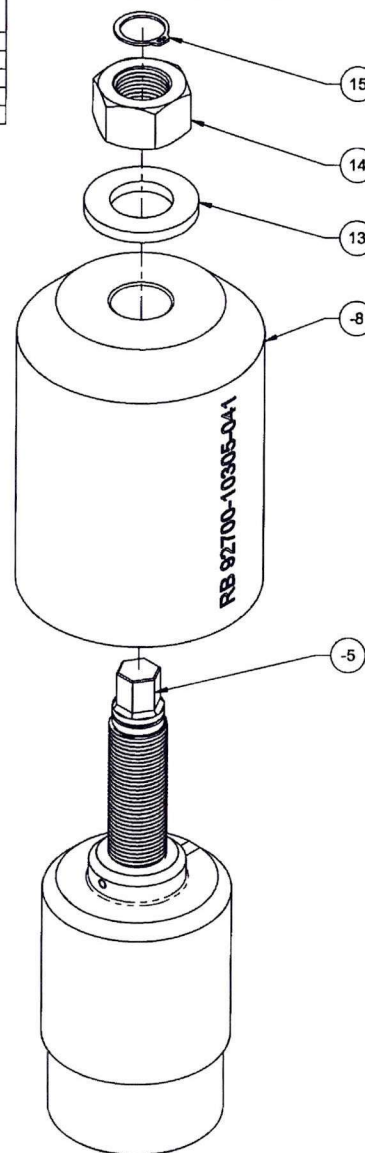
6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

8) ASSEMBLE AS SHOWN

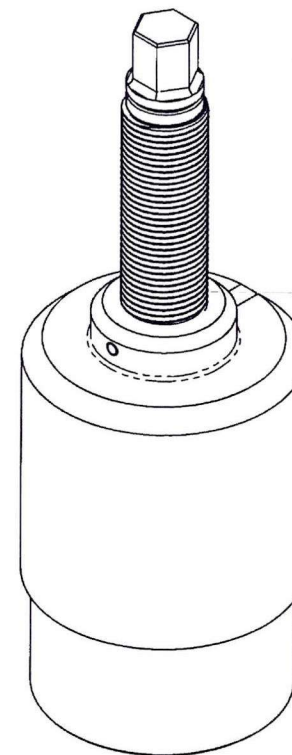
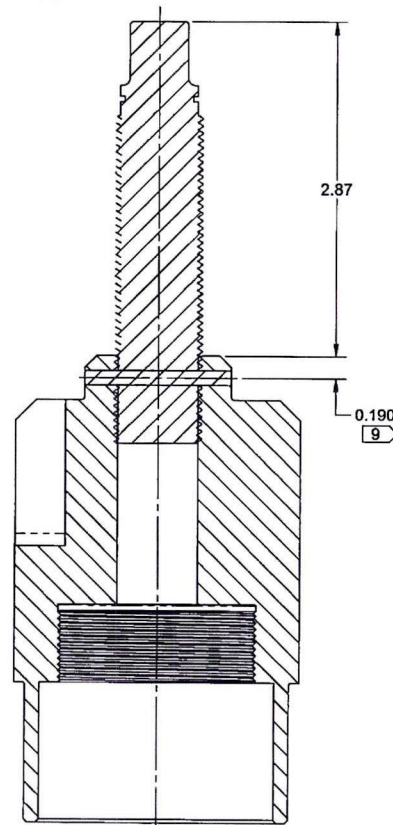
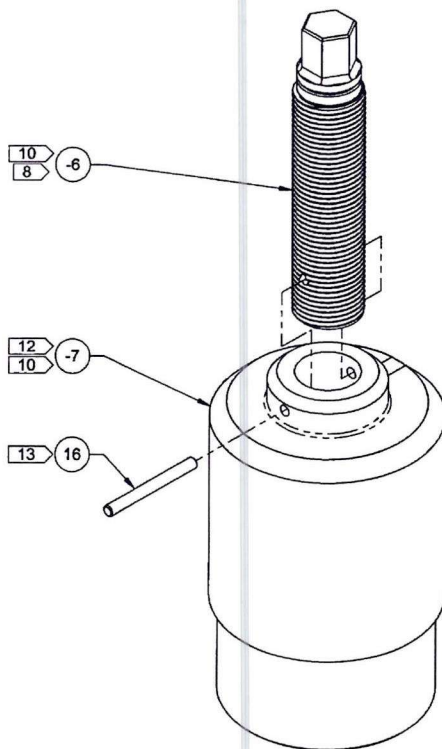
9) DOWEL PIN IN ITEM -8 MUST BE ALIGNED WITH THE SLOT OF ITEM -5 AS SHOWN

10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 5 OF 10
APPROVED	VM	TITLE	SCALE
		TGB & IGB SEAL INSTALLER	NTS
DATE	9/10/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM #	QTY	PART #	PART TITLE
-6	1	RB 92700-10305-041-6	THREADED ROD
-7	1	RB 92700-10305-041-7	PUSHER
16	1	McMaster#98381A477 OR EQUIV	STEEL DOWEL PIN 1/8" DIA. x 1-1/4" LG.

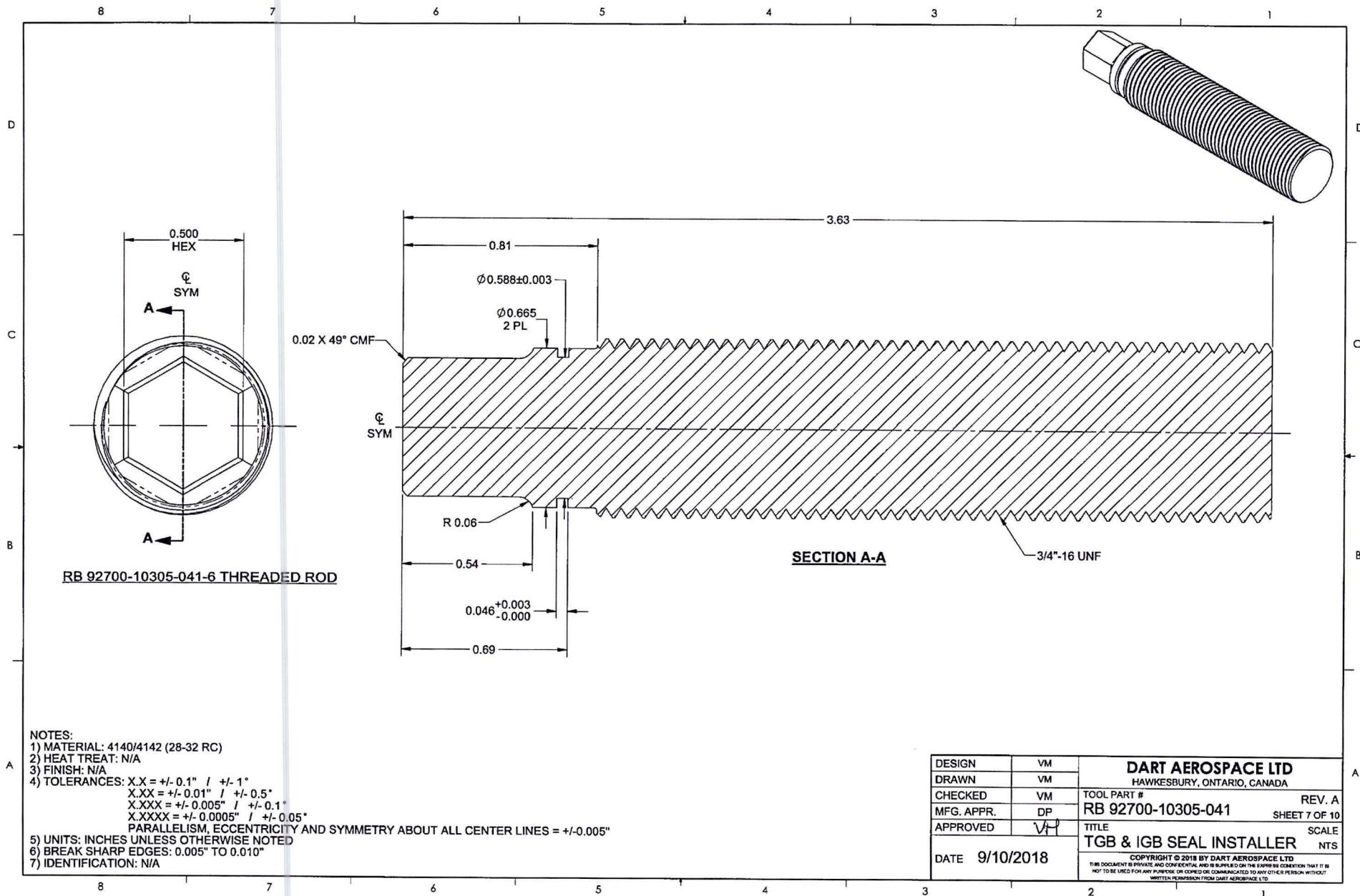


RB 92700-10305-041-5 PUSHER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) INSTALL ITEM -6 AS SHOWN
- 9) DRILL Ø0.1250"/0.1242" THRU ALL HOLE
- 10) REMOVE ITEM -6 FROM ITEM -7 AND DEBURR HOLES
- 11) FINISH MUST BE APPLIED WHEN COMPONENTS ARE UNASSEMBLED
- 12) APPLY LOCTITE 262/623 TO MATING THREADS OF ITEM -7 THEN REINSTALL ITEM -6 INTO ITEM -7 UNTIL DOWEL PIN HOLE IS ALIGNED
- 13) APPLY LOCTITE 620 ONTO MATING SURFACES OF ITEM 16 AND ITEM -7 THEN PRESS FIT ITEM 16 INTO HOLE, UNTIL FLUSH WITH SURFACE AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 6 OF 10
APPROVED	✓	TITLE	SCALE
		TGB & IGB SEAL INSTALLER	NTS
DATE	9/10/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



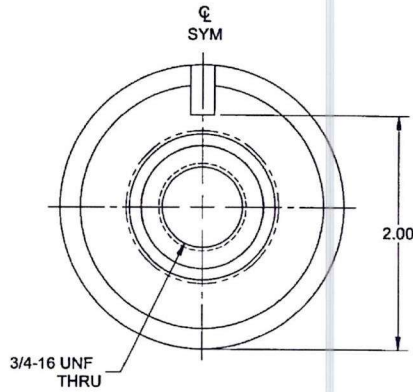
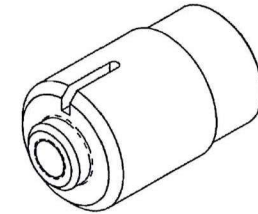
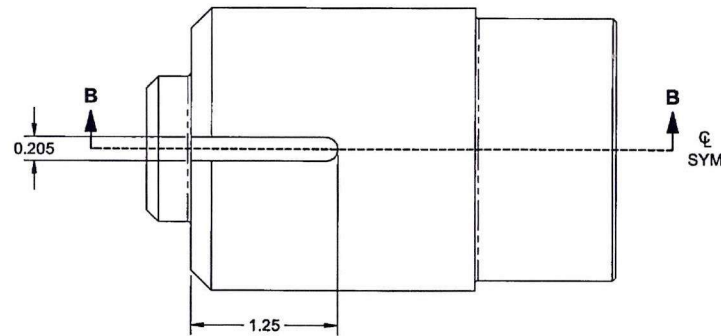
8 7 6 5 4 3 2 1

D

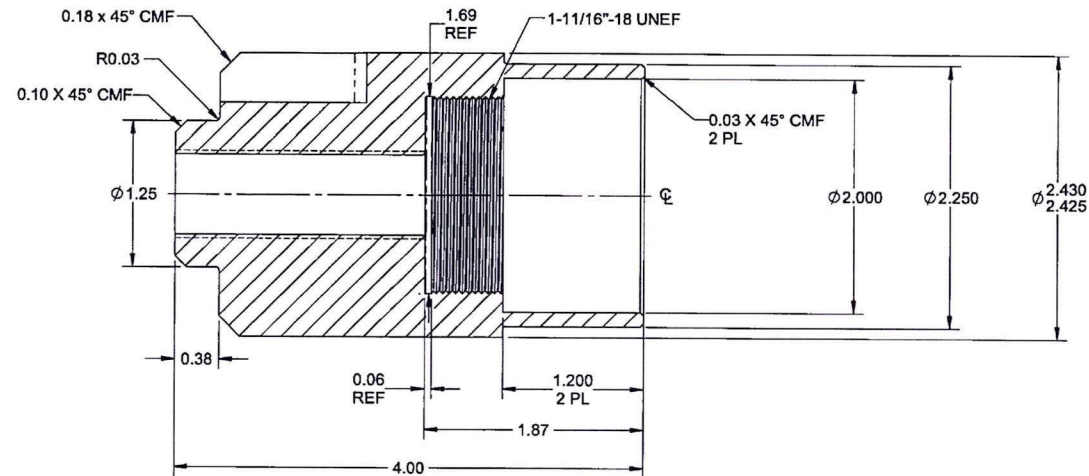
C

B

A



RB 92700-10305-041-7 PUSHER



SECTION B-B

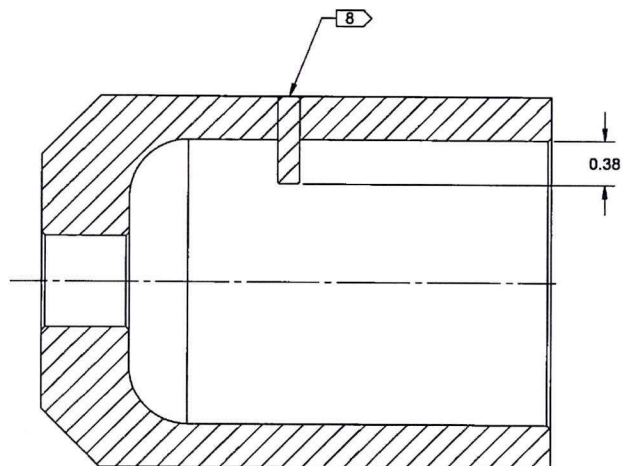
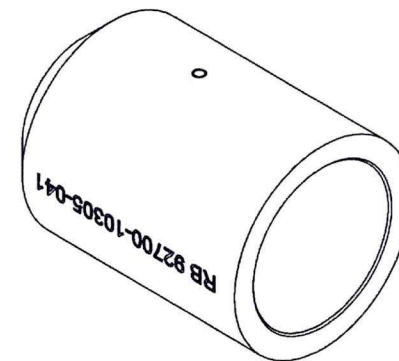
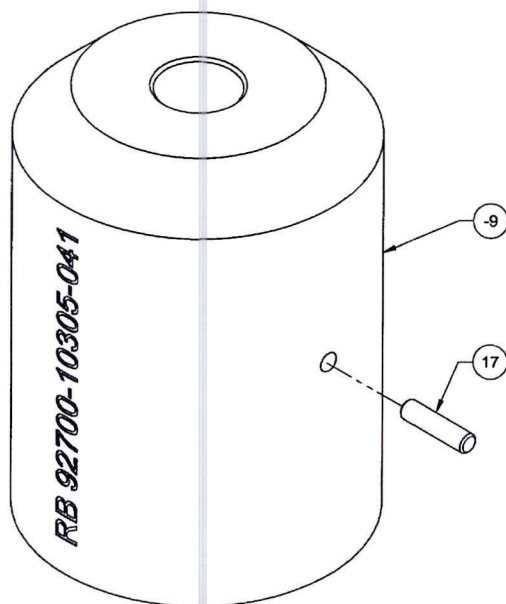
NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 8 OF 10
APPROVED	W	TITLE	SCALE
DATE	9/10/2018	TGB & IGB SEAL INSTALLER	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-9	1	RB 92700-10305-041-9	REACTOR
17	1	McMaster#98381A316 OR EQUIV	DOWEL PIN STEEL 3/16" DIA. x 3/4" LG.



RB 92700-10305-041-8 REACTOR ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
- X.XX = +/- 0.01" / +/- 0.5"
- X.XXX = +/- 0.005" / +/- 0.1"
- X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

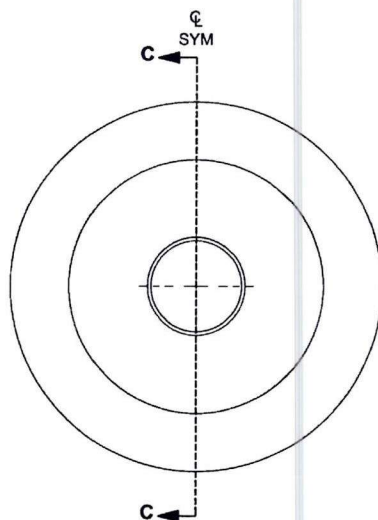
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

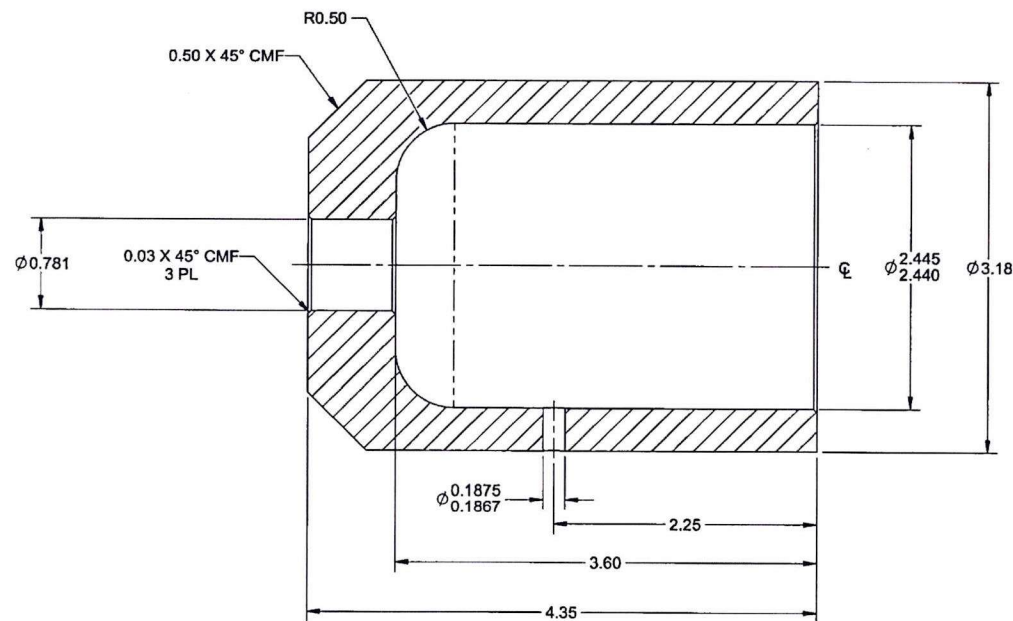
7) IDENTIFICATION: N/A

8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 17 FLUSH TO THE OUTSIDE OF ITEM -9 AS SHOWN AND REMOVES EXCESS

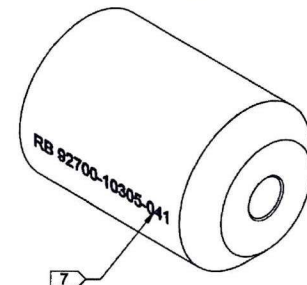
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 9 OF 10
APPROVED	VP	TITLE	SCALE
		TGB & IGB SEAL INSTALLER	NTS
DATE	9/10/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RB 92700-10305-041-9 REACTOR



SECTION C-C



NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10305-041	SHEET 10 OF 10
APPROVED	VP	TITLE	SCALE
DATE	9/10/2018	TGB & IGB SEAL INSTALLER	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					